

Work Order ID 164515***164515***

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Wednesday, July 19, 2017 2:47:23 AM

Item ID: D4306-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly
Start Date: 7/20/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/25/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: JUL 20 2017

Approvals: Process Plan: DAS Date: 10/20/2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4306	C

100 Weld per dwg A/R S.S. rod Batch: B138057 0.00***100***

Large Fab

Large Fab

Memo

0.24

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D4306-5
- 4- Drill and chamfer holes as per dwg D4306-5 using DT9710
- 5- weld bushing as per dwg D4306
- 6- grind welds flush

4x D.M.L. 2017-08-01

110

QC6- All purchased or subcontracted products 0.00

110

QC

Quality Control

Memo

0.00

DAS
43
9-894x **AUG 14 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____						
Misidentified	☐	Past Due	☐							

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120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									
QC	Memo	0.00				4x	DAS 43 9-89		
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.04							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.40					DAS 21 9-89		
Quality Control									

DAS
21
9-89

AUG 14 2017

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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164515

Parent Item: D4306-045

D4306-045

Parent Item Name: Rib Assembly

Start Date: 7/20/2017

Required Date: 7/25/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1

Manufactured

No

100

Each

31.0000

4

16

D3759-1

Bushing

**

B163886 16r 17-08-14

Location

Loc Qty

Loc Code

WA004

31

160519

31

M304TS0.750W.049

Purchased

No

100

f

873.6895

4.166

17.54105

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

B150267 2017-8-17
137824 = 21

Location

Loc Qty

Loc Code

WA004

873.689474

M137401

0.689474

M137625

482

M137824

91

M137934

300

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